Page 1 December-20-12 9:11:45 AM Item ID: D4020-11 Accept Setup Start *N900040100* **Revision ID:** Item Name: End Mesh, Basket Start Date: 12/19/12 Start Oty: 2.00 **Cust Item ID:** Required Date: 1/11/13 Rea'd Otv: 2.00 **Customer:** Reference: Run Date: 13-01-3 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject Reject **Tool ID** Tool# Plan Accept Insp. Work Center ID Description Run Hours Code Oty Oty Number Stamp Draw Nbr **Revision Nbr** D4020 Α 0.00 FLOW WATER JET Wateriet 0.00 Memo FLOW CNC Wateriet 1-Cut as per Dwg D4020 Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 Jm13.2-6

QC

Memo

0.00

Quality Control

***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON

BASKET***

120

QC8- Inspect parts - second check

0.00

120

Memo

0.00

Quality Control

***CUT OUTS WILL BE CUT BY WELDERS WHEN INSTALL ON

BASKET***

												DQA:	Date:	:
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFOR	MANCE / UPDATE				
											(QA Closed:	Date	
Vork Ord	er:						DISPOSITION			AGAINST	DEP	PARTMENT	PROCESS	
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fal Thermoforming Finishing Large Fab Composite				Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root Desc					crit	otion of work order update		nitial	Action	$\overline{}$	Sign &			
Cause		Date	Step	Qty			or Non-conformance	l	ief Eng			Date	Verification	QC Inspector
oc/Data											\neg		· · · · · · · · · · · · · · · · · · ·	
quip/Tooling											- 1			
perator											1			
laterial											1			
etup											ŀ			
ther														
rocess														
upplier														
raining														
napproved														
							F	AUL	T CATE	GORY				
Land	ing (Gear					General							
		Bending			ſ		Bend		Grain			Ovalized		Pressure/Forced
	Г	Centre No	t Concer	ntric to	o/s		BOM/Route		Hardwa	ire	П	Over/Under	tolerance	Temperature/Cure
		Cracks			Ī		Broken/Damaged	Г	Inspect	ion Incomplete	П	Part Incorred	it 🗍	Weld
		Crushed/0	Crimped.		Ī		Burrs		Instruct	ions Incomplete/Unclear	П	Part Lost/Mi	ssing	Wrong Stock Pulled
	Г	Cuffs			Ī		Contamination		Mainte	enance	П	Part Moved	_	
		Heat Trea	t		Ţ		Countersink		Mislabe	eled	П	Positioned V	Vrong	
	Г	Inspection	n Strip in	Tube			Cut Too Short	•	Misread	d	-	Power Loss/	_	Other
		Ripples in	•		1		Drill Holes		Offset				-	•
		Torque W	aves in E	xtrusio	n		Drawing		Out of	Calibration	•			
		Turning Se	equence				Finish		Out of 9	Sequence	•	· · · · · · · · · · · · · · · · · · ·		

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord	ler ID 94816
December-20-	12 9:11:45 AM
Item ID:	D4020-11
Revision ID:	

Quality Control

94816

Page 2

December-20-12	2 9:11:45 AN	<i>1</i>									
Item ID: Revision ID:	D4020-11			Accept	*N9000401	೧ ೧*	Setup	Start	*N.	S1 *	
Item Name:	End Mesh, Ba	asket						Stop	*N.S	32*	
Start Date:	12/19/12	Start Qty: 2.00	*2*		Cust Item ID:						
Required Date:	: 1/11/13	Req'd Qty: 2.00	*2*		Customer:						
Reference:							_	C4 4		_	
Approvals:	Process Pla	an:	Date:	Tooling:	Date:		Run	Start	*NF	₹1*	
	QC:		Date:	SPC (Y/N):	Date:			Stop	*NF	₹2*	
Sequence ID/ Work Center I	 D	Operation Description		Set Up/ Run Hours		lan Acce ode Qty	pt Re Qt		Reject Number	Insp. Stamp	
130		Identify as per dwg & St	ock Location: WA	7 0.00	1						
130 Packaging		Memo		0.00	Cpl 13.2.1	9 0	<u> </u>				
Packaging											
140		OC21- Final Inspection	Work Order Palacce	0.00				, ,	1		
*140		QC21- Final inspection	- Work Order Release	0.00			/	13/2	1200	XA	
OC OC		Mama		0.00				-1-	100	t7)	

												DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-	100	VFORM	MANCE / UP	DATE		·		_	*****
												QA Closed:	Dat	te:	
Work Ord	or.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
WOIK OIG	C1.					Rework	ר		Skid-tube	Crosstube		1	Water Jet	\neg	Engineering
Part I	N۵					Scrap	+		Machining	Small Fab		Pro	d. Eng. Coor.	\dashv	Quality
laici	10.				·····	Use-as-is	┪╢		noforming	Finishing	$\overline{}$	4	e/Packaging	-	Other
NCR I	۷o.					Work Order Update	1	l .	Large Fab	Composite		i inception	Supplier	-	
					-				24.86 . 42	Jomposite		J			لـــا
Root					Descri	ption of work order update	T	nitial	Ac	tion		Sign &		\Box	
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data															
Equip/Tooling		}													
Operator															
Material				}					,						
Setup															
Other															
Process															
Supplier														-	
Training															
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng (Gear				General		,				-		_	1
İ	L	Bending				Bend		Grain			L	Ovalized	:	L	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	\perp	Hardwa	re			Over/Under	tolerance	L	Temperature/Cure
	_	Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorred	ct		Weld
		Crushed/	Crimped.		1	Burrs		Instruct	ions Incomplete/	'Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Part Moved

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

December-20-12 9:11:44 AM

Work Order ID:

94816

Parent Item:

D4020-11

Parent Item Name:

End Mesh, Basket

Start Date: 12/19/12

Required Date: 1/11/13

Start Oty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 09.11.26 verified by;EC verified by:EC

IPP Rev:B as per dwg revA 10.03.15 IPP Rev:C 10.06.14 remove cut out from dxf, will be made when install on

basket DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			100	sf	1,298.4313	2.694	5.67 15789			Jm13-2-6

Location	Loc Oty	Loc Code	
WA007	1298.431264		
117197	102.9036		
120917	50.88673		
121521	0.00013372		***
122080	63.0699		
122315	11.245		
122534	160		
122604	61.238		
122884	36.5679		
123448	288		123446
123855	204.52		
124070	320		

											DQA	\: Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-C	COI	VFORI	MANCE / UP	DATE				
						<u>,</u>					QA Closed	d: Da	te:	
Work Ord	er:					DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS		·
Part I	•					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pr	Water Jet od. Eng. Coor.		Engineering Quality
NCR I	No.			,		Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/St	ore/Packaging Supplier		Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verificatio	n	QC Inspector
Doc/Data													\Box	
Equip/Tooling														
Operator														
Material														
Setup														
Other													•	
Process							1							
Supplier														
Training														
Unapproved			1											
						F	ΑUL	T CATE	GORY					
Landi	ng (Gear				General		_		-				
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to (o/s \Box	BOM/Route		Hardwa	re		Over/Und	er tolerance		Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

DOA:

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	94816
Description: End Mesh, Basket	Part Number:	D4020-11
Inspection Dwg: D4020 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.34	+/-0.030	24.34			7	Jkno6
2.88	+/-0.030	2-88-	_		V	Jeno6 Jenoi
17.31	+/-0.030	17.31			T	
15.50	+/-0.030	15.50	_		ナ	
20.18	+/-0.030	15.50° 70.15°			T	
, '						
,						
				-		
			245			

Measured by: Jyn	Audited by: 15	Preliminary Approval:	N/A
Date: (3-2-6	Date: 13-26	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	10.04.01	New Issue	KJ IA	111
В	10.08.03	Dimensions updated	KJ 😽	<u></u>

8 94816 . pl 13-01-3 23.6 D 15.13 15.61 - 19.52 -TYP 9 D4020-1 MESH (350 BASKET LONG, BASE) (SEE D4020-1F FOR LENGTH) 9 D4020-3 (350 BASKET SHORT, BASE) (SEE D4020-3F FOR LENGTH) NOTES:
1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: SEE D4020-1F & D4020-3F
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY A NEW ISSUE 10.03.04 REV. DESCRIPTION BY DATE DESIGN AJS **DART AEROSPACE LTD** DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 1 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE) NTS DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD

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D4020-5: 95.25 D4020-7: 56.00 D С 21,75 2.00 1.25 D4020-7 D4020-5 25.00 44.66 D4020-5 MESH (350 BASKET LONG, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY) D4020-7 MESH (350 BASKET SHORT, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY) NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F AJS DESIGN **DART AEROSPACE LTD** 2) FINISH: NONE 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 ibs APPROX
-7: 4.49 ibs APPROX
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06. DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 2 OF 4 TITLE APPROVED SCALE 350 BASKET MESH (BASE) NTS DE APPR. COPYRIGHT & 2010 BY DART AEROSPACE LTD

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17.31 T8> R1.44 REF 15.50 2.00 0.38 5.64 R3.38 2 PL 8 20.18 RFF 9 D4020-11 END MESH, BASKET

D

С

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A

5) BREAK SHARP EUGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN AJS DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN JPH DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 3 OF 4 TITLE APPROVED SCALE 350 BASKET MESH (BASE)

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